

Work Order ID 149291 - 1 split

Thursday, July 21, 2016 3:21:27 PM

149291

DRAB GREEN

Page 1

Item ID: D3405-041

Revision ID:

Item Name: Ground Handling Lug

Start Date: 9/20/2016 Start Qty: 10.00 2

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

JUL 22 2016

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.12

13

PR 2016/07/28
16/08/03

Pto →

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.03

13

PR 2016/07/28
16/08/03

DAS
16
9-89

16/08/08

Pto →

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.03

*13
x10

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

DQA:

Date: 2016-10-7



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: PR Date: OCT 03 2016 Work Order update only ☐

Work Order: <u>149291(-1)</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3405-041</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. <u>1676078</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
<u>SPLIT.</u>		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	16-03-05	100	all	Holes in part where found to be inconsistent, varying dimension and some with tapered R.C. operator, setup	DAS 9 9-89 16-08-05	Rework holes as per drawing using drill bit Debur - Debur - Fill in new F.A.I.	PR 2016/8/8	DAS 16 9-89 16/08/02	DAS 16 9-89 16/08/08
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☒ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 149291

Thursday, July 21, 2016 3:21:27 PM

149291

Page 2

Item ID: D3405-041

Revision ID:

Item Name: Ground Handling Lug

Start Date: 9/20/2016 Start Qty: 10.00

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr

2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

0.03

0.05

DAS
30
9-30

10

AUG 17 2016

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.03

10

DAS
38
AUG 17 2016

150

150

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

0.00

0.20

10

1609-01
JMC

116577

Work Order ID 149291

Monday, July 25, 2016 7:39:04 AM

149291

Page 3

Item ID: D3405-041

Revision ID:

Item Name: Ground Handling Lug

Start Date: 9/20/2016 Start Qty: 10.00

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.03

Quality Control

⑩ 1609.02

DAS
9
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.03

Quality Control

⑩ 1609.02

DAS
9
9-89

185

0.00

185

SprayPaint

Memo

0.00

Spray Painting

PRIME B 135172
SPRAY PAINT DRAB GREEN
B 1354132DAS
41
9-89
MP
14.09.16

Work Order ID 149291

Monday, July 25, 2016 7:39:41 AM

149291

Page 4

Item ID: D3405-041

Revision ID:

Item Name: Ground Handling Lug

Start Date: 9/20/2016 Start Qty: 10.00

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******10***

Cust Item ID:

10

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

195

QC14- Inspect Spray Paint

0.00

195

QC

Memo

0.00

Quality Control

DAS
38
9-89

SEP 15 2016

200

Identify as per dwg & Stock Location: **51534** 0.00***200***

Packaging

Memo

0.17

Packaging

2

SEP 15 2016

DAS
6
9-89

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.02

Quality Control

MWS 16-09-15
MWS 16-09-15

Picklist Print

Thursday, July 21, 2016 3:21:26 PM

Page 1

Work Order ID: 149291

149291

Parent Item: D3405-041

D3405-041

Parent Item Name: Ground Handling Lug

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	38.0000	1	10			
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D3404-1

GHW/ Lug

**

16-09-01
JL

Location	Loc Qty	Loc Code
WA001 147973	38	
145962	38	

10

M304S11GA		Purchased	No			150	sf	47.8369	0.154	1.621053			
-----------	--	-----------	----	--	--	-----	----	---------	-------	----------	--	--	--

M304S11GA

304/316 0.125 Sheet

**

PR 2016/07/28
16/08/03

Location	Loc Qty	Loc Code
MAT020	37.52998	
M129545	27.33998	
M129972	7.4	
M134284	2.79	
TPI	10.3069336	
M134604	10.3069336	

2.4

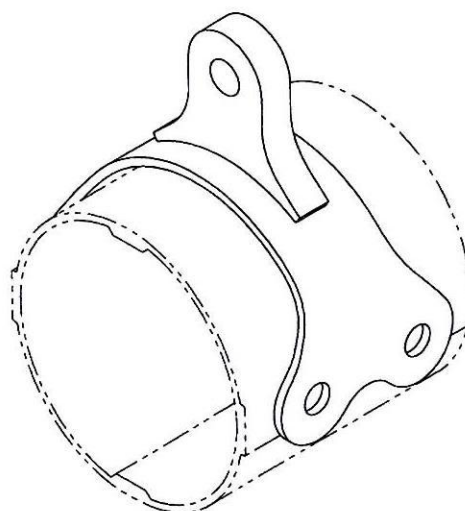
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△/B

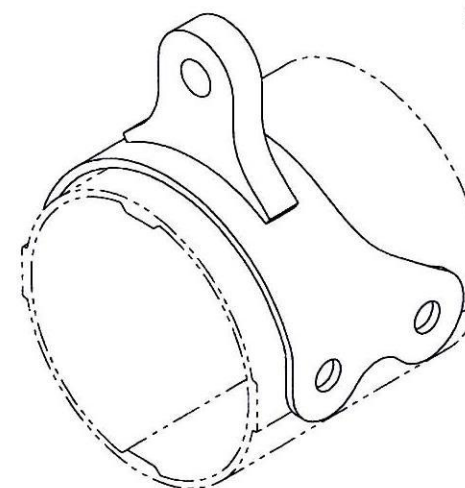
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK FILE

NO. 149291 MJS

1607-22



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



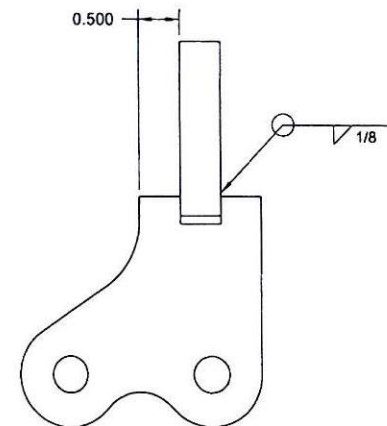
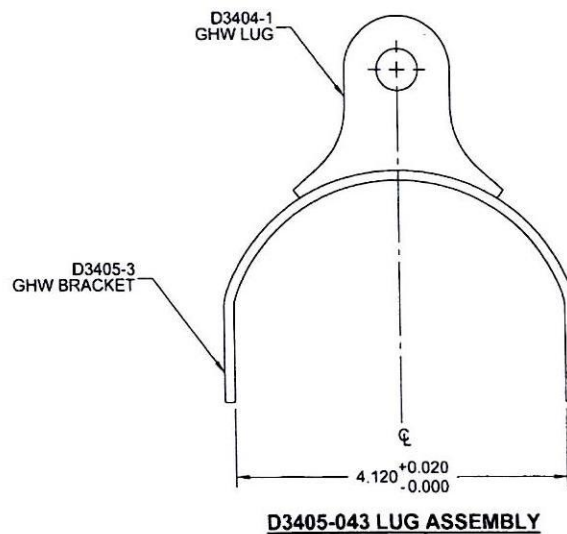
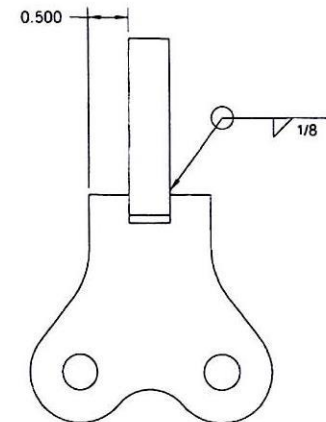
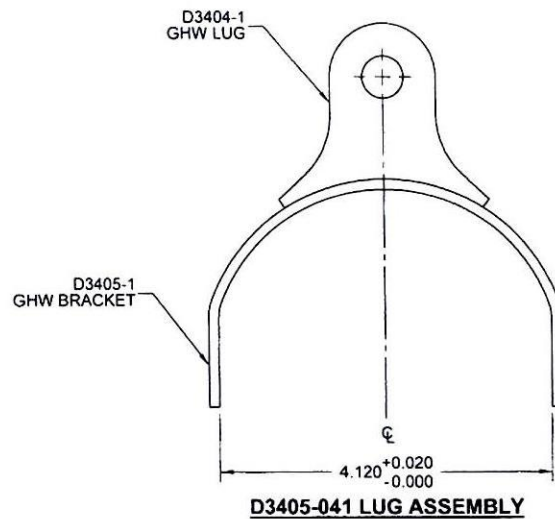
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18 MJS

NOTES:

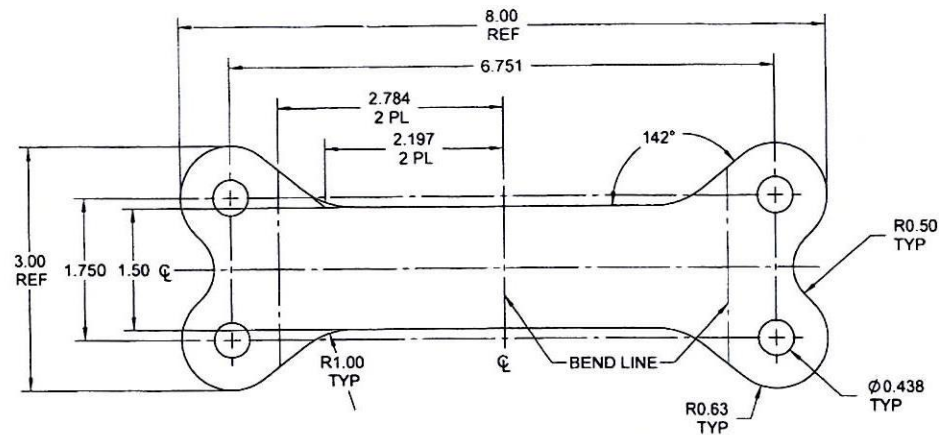
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

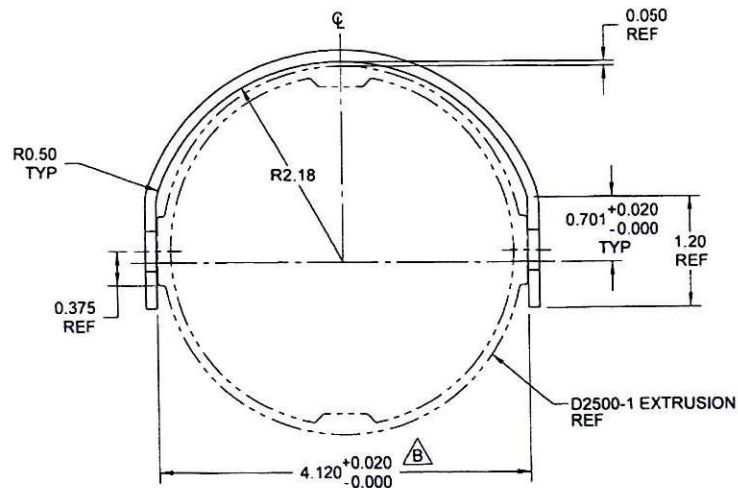


RELEASED
66/12/18 MP

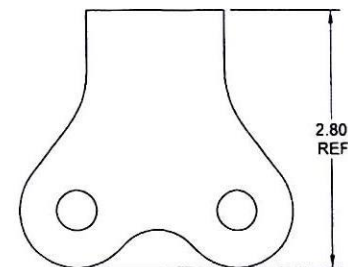
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



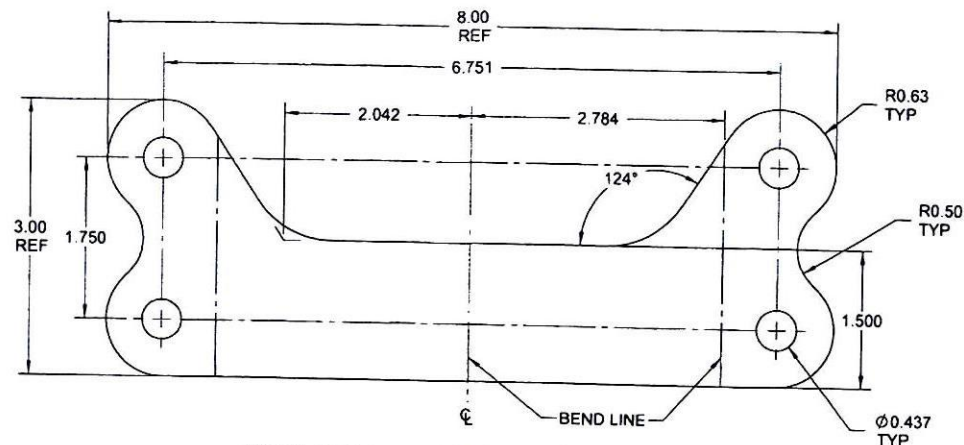
SIDE VIEW FOR REF ONLY

NOTES:

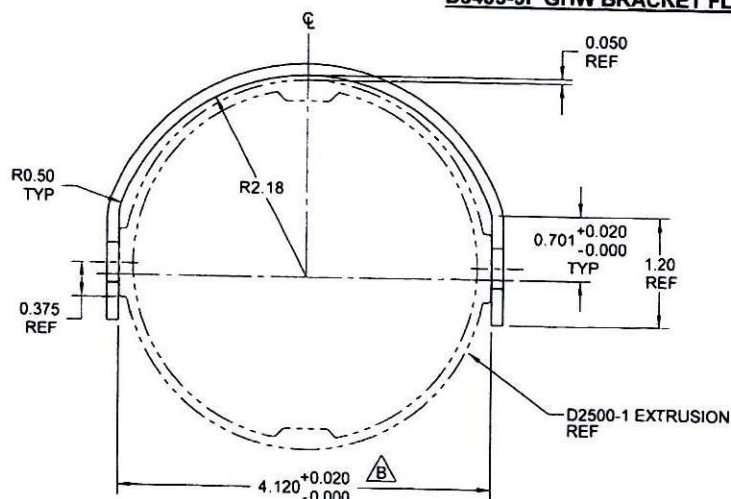
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

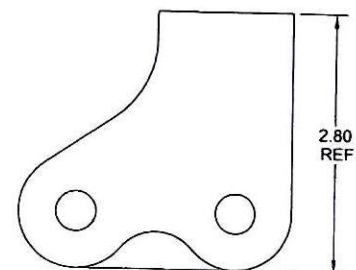
RELEASED
07/08/2014



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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